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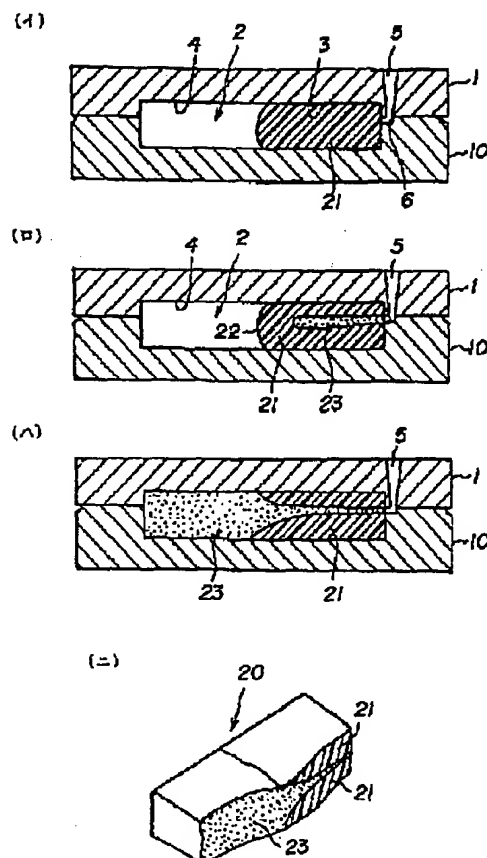
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TITLE : MOLDING METHOD OF MOLDED
FORM CONSISTING OF DIFFERENT
MATERIAL AND MOLDING DIE
THEREFOR



ABSTRACT : PROBLEM TO BE SOLVED: To provide a molding method of a molded form consisting of different materials, which permits the shortening of molding cycle as well as obtaining a die employed for molding inexpensively and, further, high connecting strength of molded forms.

SOLUTION: Upon molding a molded form by filling a hard material and a soft material into a cavity 2, consisting of a first cavity 3, molding the hard material part, and a second cavity 4 for molding the hard material part, a composite injection machine, provided with two sets of cylinders with respect to one set of injection nozzle, is employed and, at first, the hard material 21 is injected in a degree that the first cavity 3 is filled substantially. Before solidifying the hard material 21, the soft material 23 is injected into the second cavity 4 in a form that the hard material 21 is broken through the central part thereof substantially to fill the whole of the cavity 2.

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